

**Work Order ID 74297**

Wednesday, September 28, 2011 10:02:32 A



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Item Name: Rear Locker Extender

Stop



Start Date: 9/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

U

Date: 11-09-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DSI9470

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

S w l u l c o

J J L S M L S 11-11-8

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 130412  
Description: D350-604-041 Rear locker extender.  
Supplier: Delastek.  
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 118800

11-09-28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 74297**

Wednesday, September 28, 2011 10:02:33 A



Page 2

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 9/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



| Sequence ID/<br>Work Center ID    | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120<br><br>Packaging<br>Packaging | Receive & Inspect for Damage & Mat'l Certs<br>Packaging<br><br>Memo<br>Ensure a copy of Certification of Conformity and process sheet from Delastek is attached. | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |
| 130<br><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo<br>Check hole locations to template. DT 8824 Check process sheet and audit.                            | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |
| 140<br><br>Packaging<br>Packaging | Pick Kit<br><br>Memo   | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 74297**

Page 3

Wednesday, September 28, 2011 10:02:33 A

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 9/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID    | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150<br><br>QC<br>Quality Control  | QC4- 100% Inspect kits for completeness<br><br>Memo  | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |
| 160<br><br>Packaging<br>Packaging | Packaging<br><br>Memo<br>Identify and pack for shipping as per PPP D350-604-041<br>Location: _____<br>PPP Rev: _____ | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |
| 170<br><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo  | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |

11/11/14

11-11-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 28, 2011 10:02:37 AM

Page 1

Work Order ID: 74297

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender



Start Date: 9/28/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|        |  |           |    |  |  |     |      |          |   |  |  |  |  |
|--------|--|-----------|----|--|--|-----|------|----------|---|--|--|--|--|
| 2600-6 |  | Purchased | No |  |  | 110 | Each | 243.0000 | 4 |  |  |  |  |
|--------|--|-----------|----|--|--|-----|------|----------|---|--|--|--|--|



Camlock Stud

Location

Loc Qty

Loc Code

ST380

243

118611

1

118752

16

118800

136

118852

90

D350-604-041P

Purchased

No

120

Each

1.0000

1

1



Rear Locker Extender

Location

Loc Qty

Loc Code

ST

1

71968

1

D2268

Manufactured

No

140

Each

14.0000

1

1



Decal

Location

Loc Qty

Loc Code

ST010

14

69592

4

72054

10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

Wednesday, September 28, 2011 10:02:37 AM

Work Order ID: 74297



Parent Item: D350-604-041



Parent Item Name: Rear Locker Extender

Start Date: 9/28/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2269

Manufactured No

140

Each

11.0000

1

1



Decal



*[Handwritten signature]*

Location

Loc Qty

Loc Code

ST010

11

67421

1

72055

10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

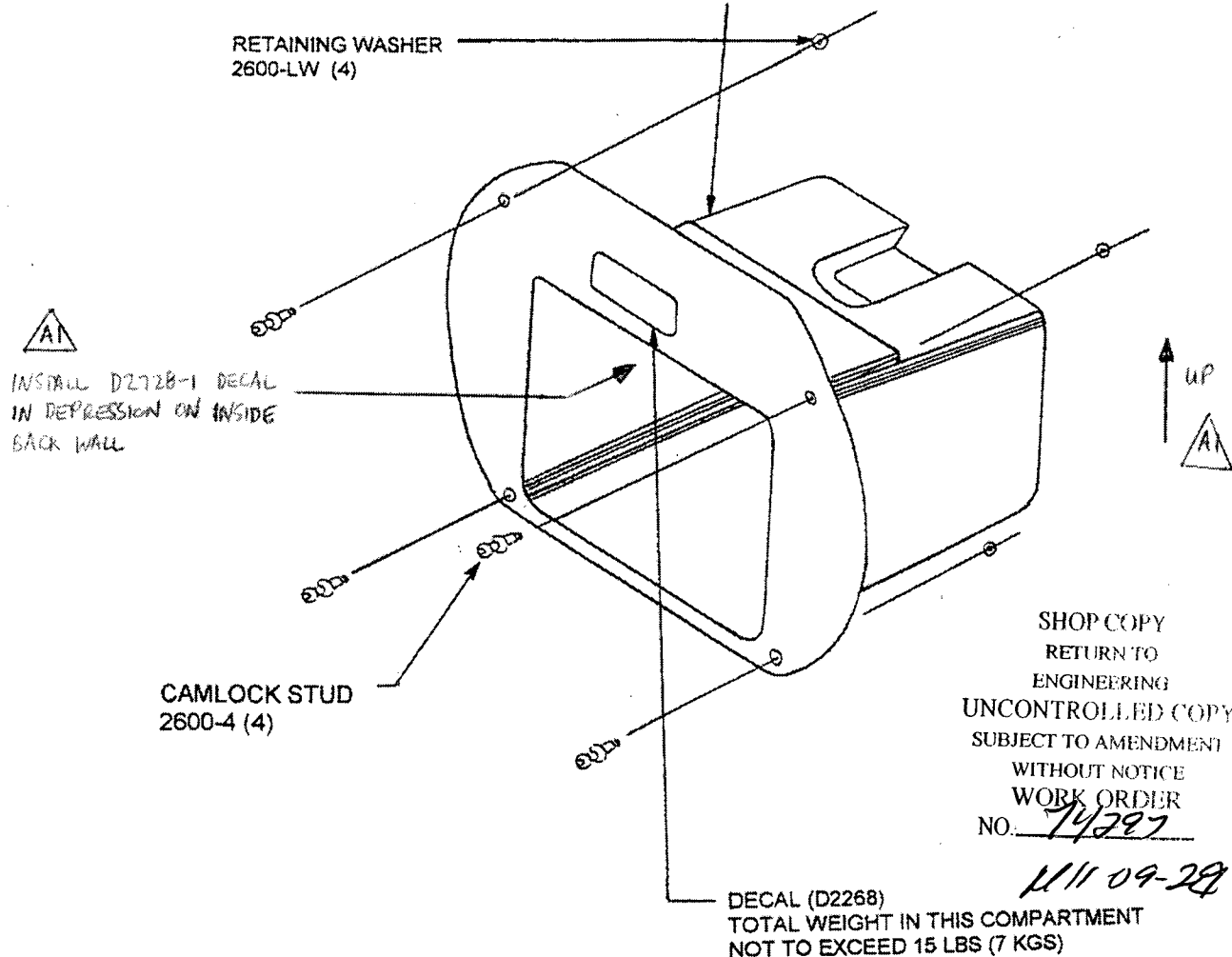
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                        |                         |  |                        |
|------------------------|-------------------------|--|------------------------|
| DESIGN<br>BW           | DRAWN BY<br>JP          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                    |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D350-604-041  | REV. A<br>SHEET 1 OF 1 |
| DATE<br>02.04.01       |                         | TITLE<br>REAR LOCKER EXTENDER ASSEMBLY                               | SCALE<br>NTS           |
| A                      | 02.04.01                | NEW ISSUE  |                        |
| AI                     | 02.04.23                | ADD D2728-1 DECAL & ORIENTATION NOTE<br>REAR LOCKER EXTENDER (D2273) |                        |

RELEASED  
02.04.03



### D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

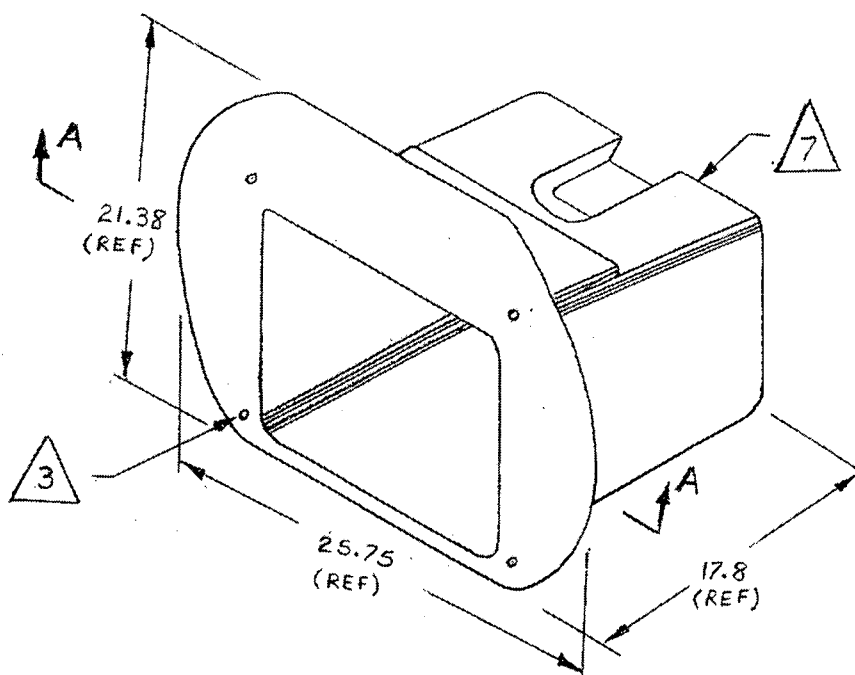
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|         |                    |                                      |                             |              |
|---------|--------------------|--------------------------------------|-----------------------------|--------------|
| DESIGN  | JB                 | DRAWN BY                             | DART AEROSPACE LTD          |              |
|         |                    |                                      | HAWKESBURY, ONTARIO, CANADA |              |
| CHECKED | <i>[Signature]</i> | APPROVED                             | DRAWING NO.                 | REV. D       |
|         |                    |                                      | D2273                       | SHEET 1 OF 1 |
| DATE    | 02.04.01           |                                      | TITLE                       | SCALE        |
|         |                    |                                      | 350 REAR LOCKER EXTENDER    | NTS          |
| B       | 96.05.27           | RE-DRAWN                             |                             |              |
| C       | 02.01.30           | CLARIFY MATERIAL, LAYUP, AND TOOLING |                             |              |
| D       | 02.04.01           | REMOVE EPOCAST, ADD SURFACE FINISH   |                             |              |

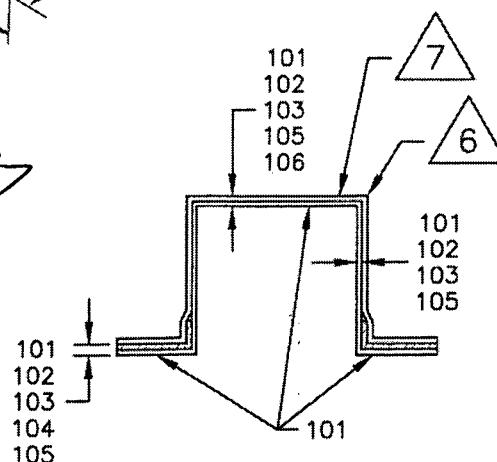
RELEASED  
02.04.03



**NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\phi 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.

74297



SECTION A-A

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

|            |         |
|------------|---------|
| Invoice #  | 41029   |
| Customer # | DART US |

Telephone: (819) 533-5788  
Warehouse: MAIN

**Bill to:**  
DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**  
DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

| Ship via         |            | F.O.B.        |                 | Terms   |  | Salesperson              |  |
|------------------|------------|---------------|-----------------|---|--|--------------------------|--|
| FEDEX P1 Collect |            | Origin        |                 | Net 30 days USA   |  | Claude Lessard, ext. 233 |  |
| Ship date        | Order Date | Our PO #      | Order by        | Your PO #   |  | GST/PST #                |  |
| 04/11/2011       | 30/09/2011 | 18880         | Brigitte Golden | 15042   |  |                          |  |
| Order Qty        | B.O. Qty   | Current Ship. | Item #          | Item Description  |  |                          |  |
| 1                | 0          | 1             | DKC134-0003     | Line #1 Rear Locker Extender D350-604-041P B74298 U de M : Each<br>Référence DKA362-0004<br>DWG: D350-604-041 REV. A1<br>D2273 REV. D<br><br><div><div>No. série</div><div>No. lot</div><div>B74297</div><div>36521</div></div> <div>Suluho</div> |  |                          |  |
| 1                | 0          | 1             | DKC134-0003     | Line #2 Rear Locker Extender D350-604-041P B74297 U de M : Each<br>Référence DKA362-0004<br>DWG: D350-604-041 REV. A1<br>D2273 REV. D<br><br><div><div>No. série</div><div>No. lot</div><div>B74298</div><div>36519</div></div>                   |  |                          |  |

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

☒ Cust.    ☐ Adm.    ☐ Quality    ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Vendredi, 2011-10-14 16:01:28  
Utilisateur: Pascal Carignan

## Feuille de Procédé

|                        |  |                 |                                |
|------------------------|--|-----------------|--------------------------------|
| Client                 | : DART US DART AEROSPACE LTD   | Nom Dessin      | : REAR LOCKER EXTENDER         |
| Numéro Job             | : 36521  | Numéro Article  | : DKC134-0003                  |
| Numéro Soumission      | : 3482   | Numéro Dessin   | : D350-604-041 & D2273         |
| Numéro B.A.            | : Kit 860  | Projet Numéro   | : DK-362                       |
| Cette fois             | : 2011-10-14 No. B.V. :  | Révision dessin | : A & D                        |
| Prsht Rev.             | : NC   | Matériel        | : Derakane 470-36/411/510      |
| Prem. fois             | : - - Type :   | Date Dûe        | : 2011-10-21 Qté: 1 UdM: UNITE |
| Job précédente         | : 36520  |                 |                                |
| Écrit par              | : _____  |                 |                                |
| Vérifié & Approuvé par | : _____  |                 |                                |
| Commentaires           | : N° de pièce Laminée Dart Aerospace: D2273<br>N° de pièce Assemblage Dart Aerospace: D350-604-041 |                 |                                |

B 74297

Process Sheet Rév.: 03 Modifier la seq. 6 Prep-general.

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description:

1.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

2.0 AMB0350 Gel Coat Blanc N° Gel 944W005

 Commentair Qty.: 1.580 UNITE(s)/Unit Total: 1.580 UNITE(s)  
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-32675-1

3.0 AMB0286 Catalyst N° DDM-9

 Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)  
 Catalyst N° DDM-9 N° de Lot: 1-27829-1

4.0 AC0747 Acetone


Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)

5.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 26 oct 11 Sceau: 



Date: Vendredi, 2011-10-14 16:01:28  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 36521

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.: Machine ou Opération: Description :

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003.

Date: 11/11/11 Sceau:



7.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 11/11/11 Sceau:



8.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total: 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-32912-1

9.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

10.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total: 4.6 VERGE(s)  
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-31000-2

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total: 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50" N° de Lot: 1-32516-1

12.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:










Humidité: 28% Température: 70.3 Heure: 11:30

Quantité: 1 Date: 02-11-11 Sceau:



Date: Vendredi, 2011-10-14 16:01:28  
Utilisateur: Pascal Carignan

## Feuille de Procédé

| Client: DART US DART AEROSPACE LTD  |                       | Nom Dessin: REAR LOCKER EXTENDER  |  |
|---|-----------------------|---|--|
| Numéro Job: 36521   |                       | Numéro Article: DKC134-0003   |  |
| Numéro Job:   |                       |      |  |
| # Séq.:   | Machine ou Opération: | Description :   |  |
| 13.0  | AMB0212               | Résine (411B7530) 411-350 promo. 75min.   |  |
| Commentair Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)<br>Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-32912                   |                       |   |  |
| 14.0  | AMB0286               | Catalyst N° DDM-9   |  |
| Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)<br>Catalyst N° DDM-9 N° de Lot: 1-27829-1                                  |                       |   |  |
| 15.0  | FINITION              | Finition Générale   |  |
|    |                       |    |  |
| Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  |                       |   |  |
| Injecter les bulles d'air selon IF134-0003 si applicable.   |                       |   |  |
| Quantité: _____ Date: _____ Sceau: _____  |                       |   |  |
| 16.0  | DÉMOULAGE             | Démoulage de la pièce   |  |
|    |                       |    |  |
| Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  |                       |   |  |
| Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager. |                       |   |  |
| Quantité: 1 Date: 3-11-11 Sceau:                       |                       |   |  |
| 17.0  | TRIMAGE               | Trimage   |  |
|    |                       |  |  |
| Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs  |                       |   |  |
| Selon IF 134-0002.  |                       |   |  |
| Faire le sablage si nécessaire.   |                       |   |  |
| Quantité: 1 Date: 3-11-11 Sceau:                       |                       |   |  |
| 18.0  | AAC1021               | Dupont Primer N° 7704S  |  |
| Commentair Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)<br>Dupont Primer N° 7704S N° de Lot: 1-30270-1                               |                       |   |  |
| 19.0  | AAC1101               | N° 7775S, Dupont Activator - Reducer Chromabase                                       |  |
| Commentair Qty.: 0.0670 UNITE(s)/Unit Total: 0.0670 UNITE(s)<br>N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-30548-3      |                       |   |  |

Date: Vendredi, 2011-10-14 16:01:28  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 36521

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:




# Séq.: Machine ou Opération: Description:

20.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 3 nov 11 Sceau:  N° fiche de Mélange: N/A

21.0 AAC1607 Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total: 4 UNITE(s)  
Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-32723-1

22.0 AAC0682 Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total: 4 UNITE(s)  
Washer 2600-LW (1127700)

N° de Lot: 1-32667-6

23.0 ASSEMBLAGE Assemblage mécanique




Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasquer la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1 Date: 4-11-11 Sceau: 

24.0 IDENTIFICATION Identification à encre indélébile




Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 36521

N° de Fabrication: 11/04/11

Quantité: 1 Date: 11/04/11 Sceau: 

25.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: Vendredi, 2011-10-14 16:01:28  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 36521

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité:

Date:

4-11-11

Sceau:



26.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité:

Date:

4-11-11

Sceau:

